

# Work Order ID 65190

Friday, January 07, 2011 10:40:13 AM



Page 1

Item ID: D3508-11

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*1-10-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508

☐ Dwg Rev: *C*

☐ Prog Rev: *C*

☐ 2-

Deburr if necessary

*B11-1-10*

*304 .040*

*(6)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B11-1-10*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Sublot*

*(+6)*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







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**Work Order ID 65190**

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Page 3

Item ID: D3508-11

Accept

Revision ID:

Item Name: Wearplate

Start Date: 1/7/2011 Start Qty: 6.00

Required Date: 1/14/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

x6 0 11/01/11

170

Identify as per dwg & Stock Location: FP-16

0.00



Packaging

Memo

0.00

Packaging

UMF 11-01-12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12 JF

UMF 11-01-12



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# Picklist Print

Friday, January 07, 2011 10:40:17 AM

Page 1

Work Order ID: 65190

Parent Item: D3508-11

Parent Item Name: Wearplate



Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC  
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

181.0714

0.5887

3.718105



304/316 .040 Sheet



B/d-1-10

Location

Loc Qty

Loc Code

MAT

178.3

115762

10.2

115953

11.1

116437

157

MAT20

2.7714

113062

1.398

115440

1.3734

116437

(6)



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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	65190
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3508-11
<b>Inspection Dwg:</b> D3508 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.066	*		V IB02	
2.813	+/-0.010	2.813	*		V	
0.375	+/-0.010	0.374	*		V	
5.625	+/-0.010	5.625	*		T B01	
22.500	+/-0.010	22.500	*		T	
26.50	+/-0.030	26.500	*		T	
Ø0.188	+0.005/-0.001	0.191	*		V	
0.300	+/-0.010	0.303	*		V	
0.300	+/-0.010	0.301	*		V	
0.038	+/-0.010	0.036	*		V	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-1-10	<b>Date:</b> 11/01/10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	AS



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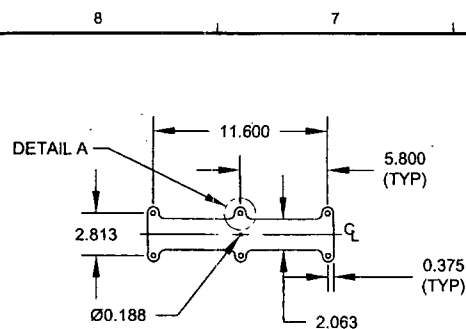
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

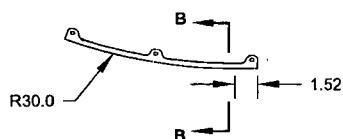
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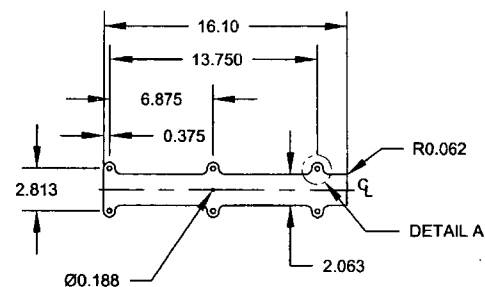




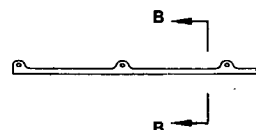
**D3508-1 FLAT PATTERN**



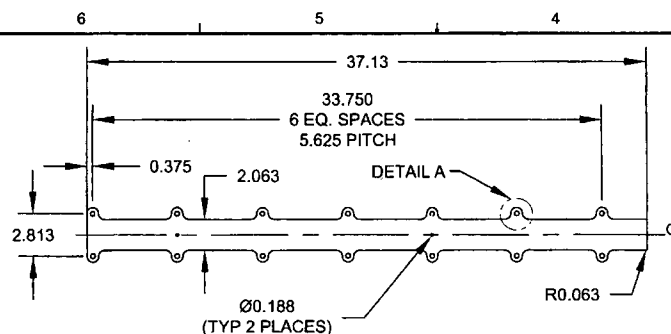
**D3508-1 BENDING DETAIL**  
(MAKE FROM D3508-1F)



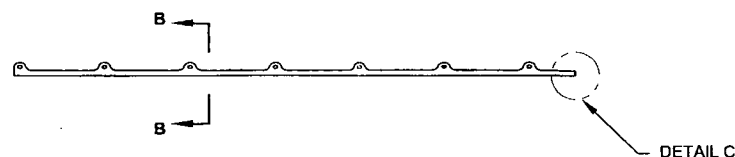
**D3508-7F FLAT PATTERN**



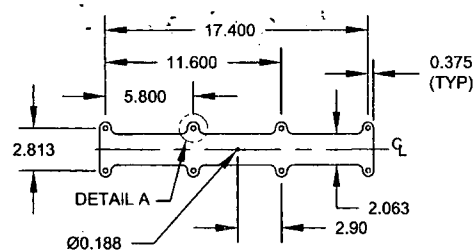
**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



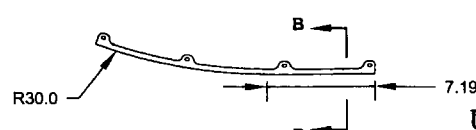
**D3508-3 FLAT PATTERN**



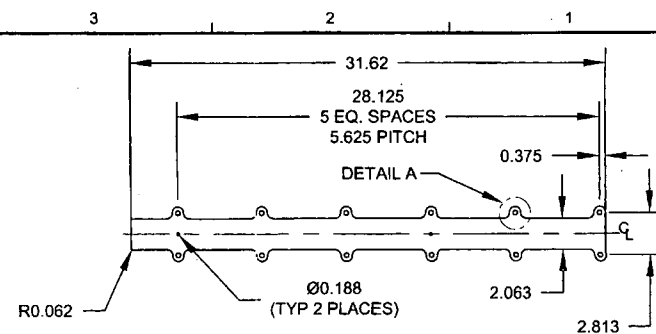
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



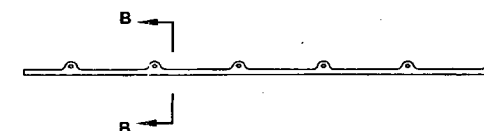
**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)



**D3508-5 FLAT PATTERN**



**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,  
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs  
D3508-13 - 0.25 lbs

**RELEASED**  
07-11-16

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

REV.	DESCRIPTION	PH	DATE
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
DESIGN	DRAWN	DATE	DATE
CHECKED	MFG. APPR.	DATE	DATE
APPROVED	DE APPR.	DATE	DATE
DATE	07.04.20	DATE	DATE

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. D3508  
TITLE WEARPLATE  
REV. C  
SHEET 1 OF 2  
SCALE 1:8  
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NO. 62196  
2/10-017



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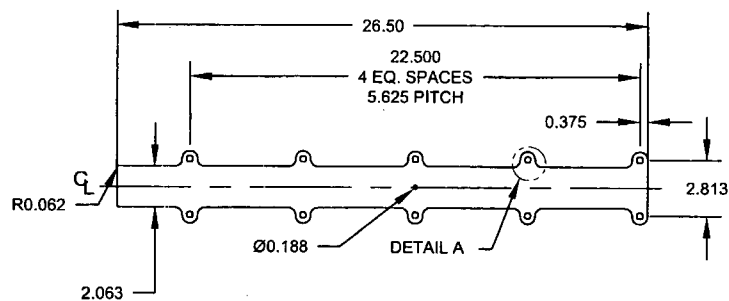
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

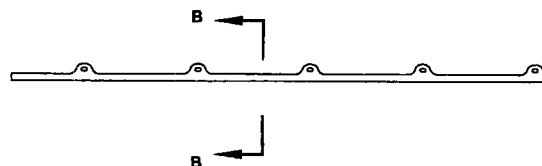
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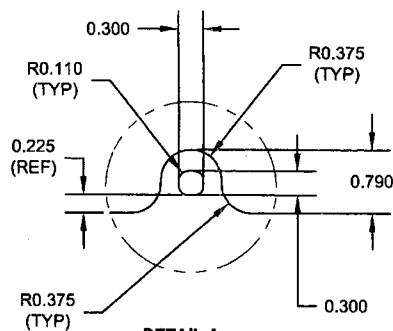




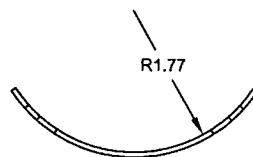
**D3508-11F FLAT PATTERN**



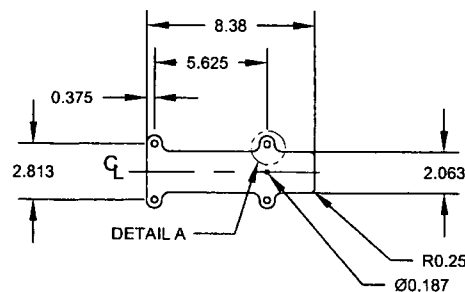
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



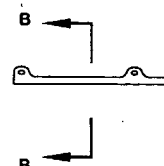
**DETAIL A**  
(SCALE 2:3)



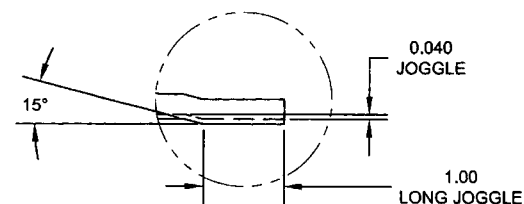
**SECTION B-B**  
(SCALE 2:3)



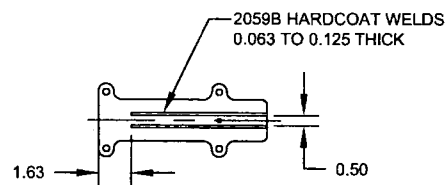
**D3508-13F FLAT PATTERN**



**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



**DETAIL C**  
(SCALE 1:2)



**D3508-13 WELDING DETAIL**

RELEASED  
07-11-16


DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



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